

Work Order ID 58835

Wednesday, May 19, 2010 1:08:34 PM



Page 1

Item ID: D3644-1	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Shim				
Start Date: 5/19/2010	Start Qty: 6.00		Cust Item ID:	
Required Date: 5/26/2010	Req'd Qty: 6.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>H</u>	Date: <u>10-5-19</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3644	Rev A								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
2074.058	1-Cut as per Dwg D3644		<input checked="" type="checkbox"/> Dwg Rev: <u>A</u>	<input type="checkbox"/> Prog Rev: <u>A</u>	<input type="checkbox"/> 2-				
	Deburr if necessary		<u>SB 10/05/02</u>						

MAT NOT PULLED

18 10-6-2

(15)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

18 10-6-2

120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

10/06/02
x15

Ph. 10/06/02
(x15)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3644-1

Accept



Setup Start



Revision ID:

Item Name: Shim

Stop



Start Date: 5/19/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

= 7 m.p 10/06/07 15X

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 10/06/07

X15 0

150

Identify as per dwg & Stock Location: 243

0.00



Packaging

Memo

0.00

Packaging

X15 BB

10/06/09

W/O:		WORK ORDER CHANGES					
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Setup Start



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Item Name: Shim

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/09
MF 10-6-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 58835



Parent Item: D3644-1



Parent Item Name: Shim

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			110	sf	33.9947	0.1664	27		



2024-T3 .050 sheet



1810-6-2

Location

Loc Qty

Loc Code

MAT22

33.9947

111381

30.9

112291

2.7

113189

0.3947

112291

(15)

W/O:		WORK ORDER CHANGES					
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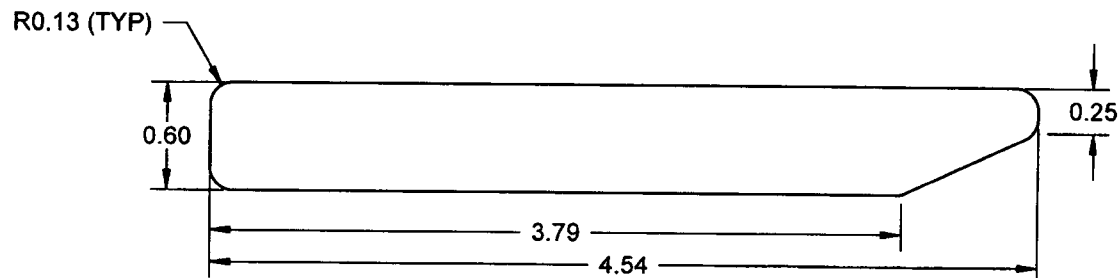
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NOTE: Date & initial all entries



D3644-1 SHIM
(REPLACES GENEVA P/N G10610-3)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 58835
PR0-579

RELEASED
 07.09.07 #

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3644-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01lbs

A	NEW ISSUE; REPLACES G10610-3		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	DTI	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	CE			
CHECKED	B	DRAWING NO. D3644	REV. A SHEET 1 OF 1	
MFG. APPR.	E			
APPROVED	NO	TITLE SHIM	SCALE 1:1	
DE APPR.	SH			
DATE	07.07.27		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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